Date!

Tuesday, 2/26/2008 7:59:52 AM

User:

Kim Johnston

## **Process Sheet**

Customer

7

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number : 37605

**Estimate Number** 

: 10173

P.O. Number

This Issue

: 2/26/2008

: NC

Prsht Rev. : 11 First Issue

Previous Run

: 36853

Type

: MACHINED PARTS

Material

**Drawing Name** 

Part Number

**Drawing Number** 

Due Date

: D2537

D2537 REV A1

: BUSHING

: N/A Project Number : A1

Drawing Revision

: 3/5/2008

Qty:

50 Um:

Each

Checked & Approved By

Comment

Written By

: Est

Material change on Step 2 KJ/JLM

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

0.500" 304 SS roundbar

1.0

M304R500

6.0165 f(s)

0.1203 f(s)/Unit Total: Material: AISI 304/316 Round Bar Ø0.500"(M304R.500)

Batch: M 105261

2.0 HARDINGE

Comment: Qty.:

HARDINGE CNC LATHE SMALL

36 04.03.07

Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA273

2-Deburr and Tumble

3.0

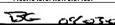
QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK

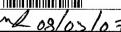


4.0

QC8

5.0

Comment: SECOND CHECK PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHAI	NGES								
DATE STEP		P PROCEDURE CHANGE By Date					Approval QC Inspector				
				ne de la companya de							
Part No	:	PAR #: Fault Category:	NCR: Yes	₩ DQ#	ı: <u>19</u> 1	Date: <u></u>	08/03/11				

QA: N/C Closed: \_\_\_\_ Date: \_

NCR:			WORK ORDE	ER NON-CONFORMANO	FORMANCE (NCR)					
		Description of NC		Corrective Action Section B				Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	QC Inspector		

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 7:59:53 AM
User: Kim Johnston Process Sheet

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BUSHING

Job Number: 37605 Part Number: D2537

Job Number: 1

Seq. #:

Machine Or Operation:

eration:

6.0

QC21

Description :

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Pt08/03/11

Job Completion



m 2008/3/10



## **Dart Aerospace Ltd**

W/O:		WORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE	By Date Q		Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	*						
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto		
		Q.		(+)						
		(4)								
		-		10						
		₩.								
				4	1.0					
							,			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37605
Description: Bushing	Part Number:	D2537
Inspection Dwg: D2537 Rev: A1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

					,	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.250	+/-0.010	1.256	<b>✓</b>			
0.316	+0.005/-0.000	.317	<u></u>			
Ø0.438	+/-0.010	.433				
	1	l	I			

Measured by:	Bir	Audited by:	and	Prototype Approval:	N/A
Date:	08.03.07	Date:	08/03/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue	KJ/RF	
В	05.02.17	Added Ø0.438	KJ/JLM 1.0	
С	07.10.31	Tolerance revised on Ø0.438	KJ/EC/DD	

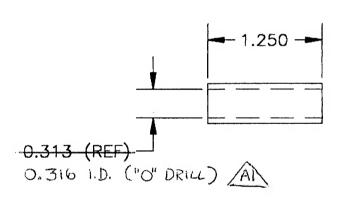




	DRAWN BY	DART AEROSPACE L		
B WILLIAMS				
CHECKED	APPROVED	DRAWING NO.		REV. A
m.m.	B6>	D2537 s	SHEET	1 OF 1
DATE		TILE		SCALE
96:05:15		BUSHING		1:1
AI 02.0	8.30 OP A	0,316 WAS 0,313		







SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

MATERIAL: 304/316 SS 7/16 OD 0.063 WALL OR 0.065 WALL

KE 91.09.07